

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026755**Date Inspected:** 21-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernie Docena and Fred Von Hoff			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	SAS OBG	

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

QA randomly observed ABF/JV qualified welder James Zhen continuing to perform Complete Joint Penetration (CJP) groove back welding fill pass on Orthotropic Box Girder (OBG) 13E/14E bottom plate 'D1' (0mm to 9900mm) outside. The welder was observed welding in the 4G (overhead) position utilizing a dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16" diameter wire electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3110-4. The welder was using a track mounted welder holder assembly that was remotely controlled. The joint being welded has the backing bar gouged using the Esab Plasma Arc machine and was ground smooth. The gouged and ground Seismic Performance Critical Member (SPCM) splice butt joint was also Non Destructive Testing (NDT) tested using the Magnetic Particle Testing (MT). The splice joint was continuously preheated to greater than 200 degrees Fahrenheit using Miller Proheat 35 Induction Heating System with the heater blankets located on top of the plate prior welding and maintained by moving the heater blanket at the side of the plate being welded during welding. The vicinity was properly protected from wind. During welding, ABF Quality Control (QC) Fred Von Hoff was noted monitoring the welding parameters of the welder. Measured welding parameters during welding were 235 amperes, 24.0 volts and 180mm travel speed. Calculated heat input was 1.9 Kjoules/mm which appears in compliance to the contract requirements. At the end of the shift, FCAW-G cover pass welding was completed. The welder has held the preheat of more than 200°F for three (3) hours after welding as required.

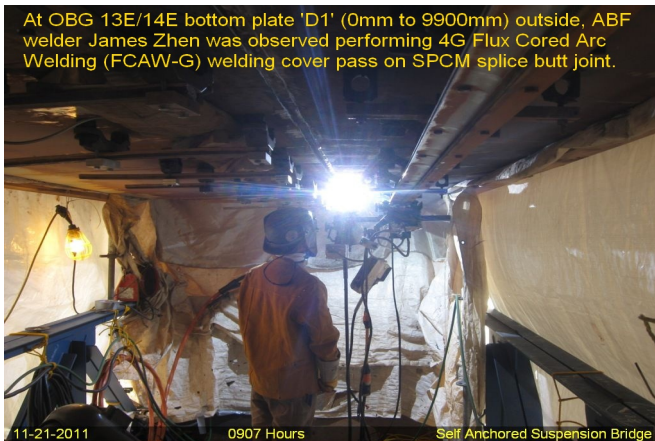
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At OBG 13E/14E vertical plate 'I' outside, QA randomly observed ABF personnel Wai Kitlai and Han Wen Yu perform preparation for the back welding of the vertical plate. The welders were noted putting in place wind and rain protection to be used during welding. After the completion of the preparation, the welders have tried to line up the welding parameters but have noted the wire feeder was not functioning properly. There was no welding performed today.

At OBG 13E/14E edge plate 'F' inside, QA randomly observed ABF/JV qualified welder Fred Kaddu continuing to perform root pass to fill pass welding on the Complete Joint Penetration (CJP) splice butt joint. The welder was observed manually welding in the 3G (vertical) position utilizing a Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1040B. The joint being welded has a single V-groove butt joint with backing bar that will be removed and back gouged. Prior welding, the plates were preheated to 150°F using propylene gas torch. During welding, ABF Quality Control (QC) Bernie Docena was noted monitoring the welding parameters of the welder. Measured welding parameter during welding was 130 amperes on a 1/8" diameter E7018H4R electrode. At the end of the shift, fill pass SMAW welding was still continuing and should remain tomorrow.

This QA Inspector verbally informed QA SPCM Lead Inspector, Daniel Reyes, of the issues noted in this report for compliance therefore for further details of issues of significance see QA SPCM Lead Inspector, Daniel Reyes, Daily Inspection Report (6031) for this date.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer